



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4330-3
Job Sheet 179827



Part No: D4330-3

Job Qty: 6 ea

Part Name: Door Bracket



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/22/18

Job Tracking No:

Due Date: 7/6/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A SHEETS 4,5 IPP Rev:A 11.02.17 new issue DD verified by: EC IPP REV:B 11.08.18 per dwg revA. DD Verf:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	7/6/18	7/6/18	0.00	0.00	Start Up Waterjet		SC 18/06/23
100	Waterjet	6 pcs	7/6/18	7/6/18	0.00	0.19	Waterjet1		SC 18/06/23
120	QC	6 pcs	7/6/18	7/6/18	0.00	0.00	QC8		38
130	Brake NC	6 pcs	7/6/18	7/6/18	0.01	0.54	Brake NC 2		38
140	QC	6 pcs	7/6/18	7/6/18	0.00	0.00	QC5		38
150	HandFinish	6 pcs	7/6/18	7/6/18	0.00	0.37	HandFinish1		38
155	Powdercoat	6 pcs	7/6/18	7/6/18	0.00	0.29	Powdercoat3		38
160	QC	6 pcs	7/6/18	7/6/18	0.00	0.00	QC3		38
170	Packaging	6 pcs	7/6/18	7/6/18	0.00	0.00	Packaging3-2	5108790	JUL 05 2018
180	QC21-SA	6 Ea	7/6/18	7/6/18	0.00	0.00	QC21		JUL 05 2018

Part Op 100 - 1-Cut as per Dwg Dwg Rev: 4 Prog Rev: 4 2-Debur if necessary
Descriptions: 155 - POWDER COAT: Start Time: 300 Oven Temperature: 300 Finish Time: 300

M 136370

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.080	6061-T6 .080 Sheet	.8412 sf (.1402 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6S.080	1	78	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Door Bracket	0.316Inches + 0.006 - 0.001	0.322 0.315	0.718 Diameter	
2	Door Bracket	3.000Inches ± 0.030	3.030 2.970	2.995	
3	Door Bracket	2.130Inches ± 0.030	2.160 2.100	2.127	
4	Door Bracket	1.500Inches ± 0.030	1.530 1.470	1.501	
5	Door Bracket	0.870Inches ± 0.030	0.900	0.868	



WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____
QA Closed: _____ Date: _____

Work Order update only

DISPOSITION		AGAINST DEPARTMENT/PROCESS	
Work Order: _____	☐ Rework	Skid-tube _____	Cross tube _____
Part No. _____		_____ Machining	Small Fab _____
NCR No. _____			Water Jet _____
Date : _____			Prod. Eng. Coord. _____
Step #: _____			Rec/Store/Packaging _____
Suspected Unai _____			Engineering _____
Description Work Order Deviation _____			Quality _____
			Other _____

Container No: S083567

Part: D4330-3

Job No: 179827

Serial No/Batch: S083567

Revision: A

Inspector: _____

Exp Date: _____

Instructions: _____

3y

approval

supervisor

ification

Coordinator

approval

Dart Aerospace Ltd.

1270 Aberdeen Street

Hawkesbury, ON K6A 1K7

CANADA

TEL.: 1 813 632-5200

Email: sales@dartaero.com

www.dartaerospace.com

Date: 08/24/18

			0.840	
6	Door Bracket	2.110Inches ± 0.030	2.140 2.080	2,113
7	Door Bracket	2.740Inches ± 0.030	2.770 2.710	2,746
8	Door Bracket	0.080Inches ± 0.010	0.090 0.070	0,080

Plex 6/22/18 9:59 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							